

split

Date: Thursday, 9/20/2007 3:29:10 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	34749		Part Number	D2572		
Estimate Number	10531		Drawing Number	D2572 REV E		
P.O. Number	N/A		Project Number	N/A		
This Issue	9/20/2007	S.O. No.	Type	MACHINED PARTS	Drawing Revision	E
Prsht Rev.	NC		Material	N/A	Due Date	10/1/2007
First Issue	N/A		Qty:	10	Um:	Each
Previous Run	34368					
Written By						
Checked & Approved By	<u>John.09.20</u>					
Comment	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B3138Y</u>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>3.18</u> Double check by: <u>ML</u> <u>34749</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			

RG 07.10.21 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/23		Split WO	u	4			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:29:10 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 34749

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 07/10/24 (4)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(4X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-k

07/10/25

7.0 POWDER COATING POWDER COATING



M105068



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-k

07/10/25

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



MJ



(4X)

Comment: INSPECT POWDER COAT

07-10-25

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1



(4X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

07/10/26

AJ (4X)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/26

Job Completion



u 07/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34749
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.441	.441	.441	.441		
B	1.745	1.755		1.748	1.748	1.748	1.749		
C	3.495	3.505		3.499	3.499	3.498	3.500		
D	1.745	1.755		1.748	1.748	1.748	1.749		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510		0.500	.500	.502	.507		
G	0.257	0.262	DT8683	.257	.257	.257	.257		
H	0.375	0.380	DT8684	.371	.371	.371	.375		
I	0.490	0.510		.500	.501	.501	.501		
J	1.174	1.184		1.175	1.175	1.179	1.180		
K	0.558	0.578		.568	.568	.578	.568		
L	1.174	1.184		1.179	1.179	1.179	1.180		
M	1.490	1.500		1.496	1.496	1.496	1.500		
N	2.495	2.505		2.500	2.500	2.501	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.875		
P	0.115	0.135		.124	.122	.122	.122		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.250		
S	0.115	0.135		.134	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.967	2.962		
V	0.230	0.250		.240	.240	.235	.240		
W	0.115	0.135		.130	.130	.133			
X	0.307	0.312		0.312	.312	.312	.312		
Y	0.760	0.765		0.760	.760	.760	.760		
Z	0.352	0.372		0.366	.366	.366			
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.627	.627	.627			
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.245	.245		
AE	1.375	1.395		1.393	1.386	1.397	1.390		
AF	0.115	0.135		.135	.135	.131	.135		
AG	0.240	0.280		.250	.280	.280	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.001	2.003		
AJ	0.023	0.043		.033	.033				

Accept/Reject

Measured by: J.P.
Date: 07/10/18

Audited by: J.F.
Date: 07/10/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>JF</u> <u>JLM</u>

DART AEROSPACE LTD				Work Order:	34749
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5*	6*	7*	8*		
A	0.438	0.443	DT8682	.491	440	440	440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.005	8.005	8.005		
F	0.490	0.510		.500	.507	.507	.507		
G	0.257	0.262	DT8683	.257	.257	.257	.257		
H	0.375	0.380	DT8684	.375	.375	.375	.375		
I	0.490	0.510		.505	.504	.504	.505		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.254	.254	.250		
S	0.115	0.135		.125	.126	.126	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.130	.125	.125	.125		
X	0.307	0.312		.310	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.350	.355	.355	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.258	.258	.250		
AE	1.375	1.395		1.388	1.388	1.388	1.388		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.003	2.002	2.001	2.000		
AJ	0.023	0.043		.032	.033	.033	.033		

Accept/Reject

Measured by: *SR*
Date: 07/10/21

Audited by: *J.F.*
Date: 07/10/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i> <i>JL</i>	

DART AEROSPACE LTD	Work Order:	34749
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

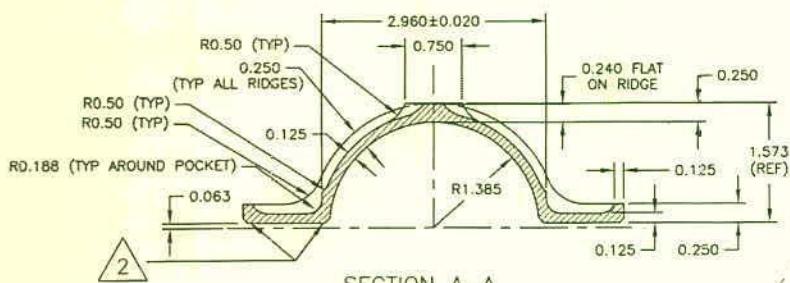
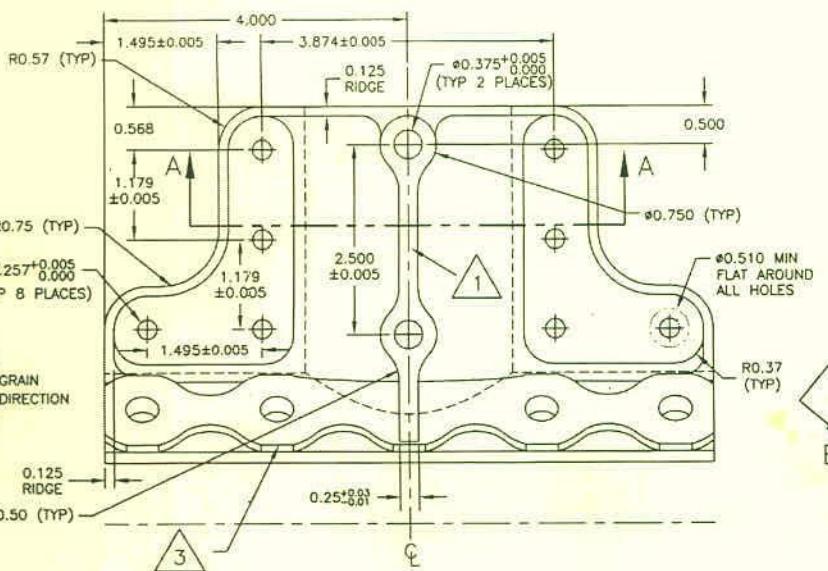
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.005	8.005				
F	0.490	0.510		.503	.503				
G	0.257	0.262	DT8683	.257	.256				
H	0.375	0.380	DT8684	.375	.376				
I	0.490	0.510		.505	.505				
J	1.174	1.184		1.180	1.179				
K	0.558	0.578		.566	.568				
L	1.174	1.184		1.180	1.179				
M	1.490	1.500		1.500	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.125	.122				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.123	.125				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.962	2.962				
V	0.230	0.250		.240	.240				
W	0.115	0.135		.122	.122				
X	0.307	0.312		.312	.312				
Y	0.760	0.765		.762	.762				
Z	0.352	0.372		.362	.362				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.630	.630				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.260				
AE	1.375	1.395		1.387	1.387				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.249	.249				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: *J.P.*
Date: 07/10/22

Audited by: *J.F.*
Date: 07/10/22

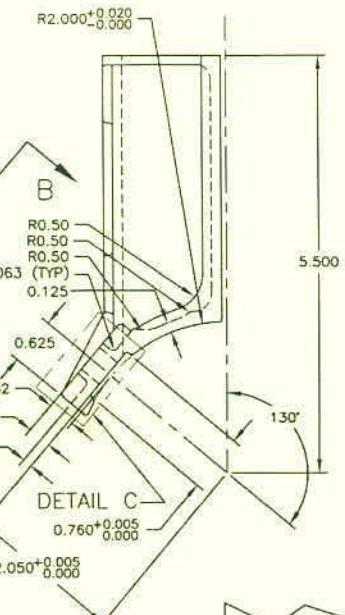
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i> <i>JL</i>	





SECTION A-A

DETAIL C
SCALE 2:1

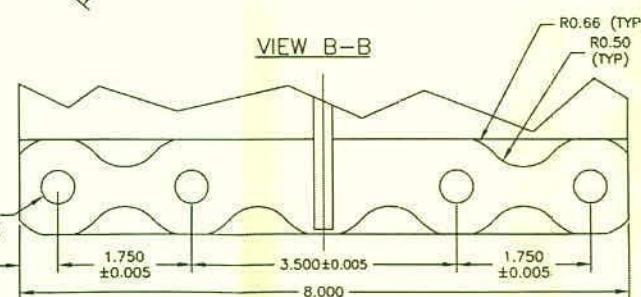


NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. QEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD.
DS	PH	HAWKSBURY, ONTARIO, CANADA
CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO. D2572
DATE 05.07.13		REV. E SHEET 1 OF 1 TITLE INNER FWD SADDLE SCALE 2:1

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